

CLAIMS AMENDMENTS

1. (currently amended) Process for producing cigarette packs (10) of the hinge-lid type with an outer wrapper made of film and with a tear-open strip (12) applied to the outer wrapper, characterized by comprising the following steps of:
 - a) attaching the tear-open strips (12) to drawing a continuous film web (13) off of a reel (15),
 - b) severing blanks (11) for the outer wrapper from the continuous film web (13),
 - c) drawing a material strip (18) for producing the tear-open strip (12) is provided with off of a separate strip reel (19), the material strip (18) having precisely positioned printing or markings (24) thereon, and feeding the material strip (18) to the continuous film web (13),
 - c) applying the material strip (18) to the continuous film web (13),
 - d) sensing the printing or markings (24) on the material strip (18) for producing of the tear-open strip (12) are sensed by a print-mark reader (26) after the material strip (18) for producing the tear-open strip (12) has been attached applied to the film web (13), and then
 - e) severing blanks (11) for the outer wrapper from the continuous film web (13) to which the material strip (18) has been applied, wherein a severing cut for severing the blanks (11) with the tear-open strips (12) from the continuous film web (13) is controlled in accordance with the detected printing or markings (24) of the tear-open strip (12).
2. (withdrawn) Process according to Claim 1, characterized in that the film web (13) (also) has printing, markings, printed marks (25) or the like, and in that said printing, printed marks (25), etc. are sensed by sensors - printed-mark readers (30) - preferably by separate printed-mark readers (30) assigned to said printing or printed marks (25) of the film web (13).

3. (withdrawn) Process according to Claim 1, characterized in that the printing, markings (24) and/or printed marks (25) sensed by the sensors or printed-mark readers (26, 30) are evaluated for the purpose of controlling the drive of the film web (13) and/or of the material strip (18).

4. (withdrawn) Process according to Claim 1, characterized in that, for the purpose of changing the position of the tear-open strip (12) and/or of the printing, markings (24), etc. applied thereto, the tear-open strip (12) or the material strip (18) for producing the tear-open strip (12) is extended or lengthened.

5. (withdrawn) Process according to Claim 1, characterized in that, in the case of double-web operation - namely during the synchronous production of two blanks (11) by severing them from two parallel film webs (13), each with a tear-off strip (12) - two material strips (18) are in each case drawn off from an associated reel, namely single reel (46, 47), or from a common strip reel (45) and are guided during transport to the two film webs (13) at a distance from one another corresponding to the position on the two film webs (13) and at the same time are laid on the film webs (13) with the corresponding position of the markings (24).

6. (currently amended) Apparatus for producing cigarette packs (10) of the hinge-lid type, with an outer wrapper made of film and with a tear-open strip (12) applied to the outer wrapper and likewise consisting of film, in which blanks (11) for the outer wrapper are severed from a continuous film web (13) that has a tear-open strip (12) applied thereto, characterized by the following features comprising:

- a) a strip reel (19) containing the a material strip (18) for producing the tear-open strips (12), the material strip (18) is provided with having precisely positioned printing or markings (24) thereon, the material strip (18) being held ready on the strip reel (19) for being drawn off along a path of movement,
- b) a reel (15) containing the continuous film web (13), the continuous film web (13) being held ready on the reel (15) for being drawn off along the path of movement,
- c) a means for applying the material strip (18) to the continuous film web (13) along the path of movement,
- d) a printed-mark reader (26) located in the region of the path of movement of along which the material strip (18) for producing the tear-open strips (12) connected is applied to the film web (13), the film web (13) is assigned a wherein the printed-mark reader (26) for the purpose of sensing senses the printing or markings (24) of the material strip (18) for producing the tear-open strips (12),
- e) the printed-mark reader (26) is connected to an evaluation unit, connected to the printed-mark reader (26), for evaluating the detected positions of the printing or markings (24) on the material strip (18) for producing the tear-open strip (12) sensed by the printed-mark reader,
- f) a means for severing the blank (11) containing the tear-open strip (12) from the continuous film web (13) to which the material strip (18) has been applied, and
- g) drive elements for the continuous film web (13), whereby the drive elements are controlled by the printed-mark reader (26) via the evaluation unit.

7. (withdrawn) Apparatus according to Claim 6, characterized in that at least two sensors - printed-mark readers (26, 30) - are provided for the purpose of sensing printing, markings (24), printed marks (25), etc. both of the material strip (18), or of the tear-open strips (12), and of the film web (13), printing, printed marks (25), etc. of the film web (13) being positioned in an offset manner in relation to the material strip (18) or to the tear-open strips (12).

8. (withdrawn) Apparatus according to Claim 6, characterized in that conveying elements for the material strip (18) and/or the film web (13) provided with material strip (18) and/or tear-open strip (12) can be controlled by the sensors - printed-mark readers (26, 30) - in respect of changing the drive speed of the film web (13) and/or material strip (18).

9. (withdrawn) Apparatus according to Claim 8, characterized in that conveying rollers (31, 37) and/or drive rollers (28) assigned to the film web (13) and/or the material strip (18) can be driven by controllable servomotors (29, 33), it being possible for the servomotors (29, 33) to be controlled by the printed-mark readers (26, 30).

10. (withdrawn) Apparatus according to Claim 9, characterized by the following features:

- a) a controllable drive roller (28) is arranged in the region of the film web (13), provided with tear-open strip (12) or material strip (18), preferably immediately upstream of a blank station (14),
- b) a further controllable drive roller (31) is positioned in the region of the material strip (18),
- c) the two drive elements - drive roller (28) and conveying roller (31, 37) - can be controlled by sensors - printed-mark readers (26, 30) - assigned to the tear-open strips (12) or the material strip (18), on the one hand, and to the film web (13), on the other hand.

11. (withdrawn) Apparatus according to Claim 10, characterized in that a controllable conveying roller (37) for the material strip (18) is positioned adjacent to a severing subassembly for severing tear-open strips (12) from the material strip (18), in particular adjacent to a cutter roller (36).

12. (withdrawn) Apparatus according to Claim 6, characterized in that it is possible to produce blanks (11) with tear-open strips (12) in double-web operation, it being possible to produce from a double web (39), by severing it centrally, two parallel film webs (13) and from a double strip (41), by severing, two parallel material strips (18), and it being possible for the two film webs (13) and material strips (18) to be controlled by common sensors - printed-mark readers (26, 30) - by way of separate conveying elements.

13. (withdrawn) Apparatus according to Claim 6, characterized in that, for double-web operation, two separate material strips (18) can be drawn from a common strip reel (45) while being directly adjacent to one another in each case, or from two separate, single reels (46, 47) arranged adjacent to one another, with the material strips (18) at a distance to one another, and can be fed to the two film webs (13), with the material strips (18) being transferred to the film webs (13) by means of guide members spaced at an precise distance from one another.

14. (withdrawn) Apparatus according to Claim 13, characterized in that, as two separate material strips (18) are drawn off from a common strip reel (19), deflecting elements are provided for the purpose of deflecting in a transversely directed manner the material strips (18), which are fed closely together, at a distance apart from one another which corresponds to the sheet webs (13), preferably guide rollers (59, 60, 62).

15. (withdrawn) Apparatus according to Claim 13, characterized in that, in double-web operation, two reels, namely single reels (46, 47), each for a material strip (18) are arranged on a common carrier, in particular on a common, continuous reel sleeve (63), on a common bearing journal (65), such that the single reels (46, 47) always execute corresponding rotary movements as the material strip (18) are drawn off.

16. (withdrawn) Reel for material strips (18) for the production of a tear-open strip (12) to be attached to a blank (11), with the material strip (18) drawn off the reel is laid on a film web (13) and it being possible to sever the blanks (11) with tear-open strip (12) from the latter, characterized in that in order to feed two material strips (18) to one film web (13) (each) the two material strips (18) are wound on a common carrier, in particular on a common reel shell or on a common reel core (63).

17. (withdrawn) Reel according to Claim 16, characterized in that two single reels (46, 47) are wound on the common reel core (63) at a slight distance from one another, preferably with a matching winding structure.

18. (withdrawn) Reel according to Claim 16, characterized in that two immediately adjacent, parallel material strips (18) can be wound on a single, common strip reel (45) and can be drawn off together as a unit.

19. (withdrawn) Process according to Claim 2, characterized in that the printing, markings (24) and/or printed marks (25) sensed by the sensors or printed-mark readers (26, 30) are evaluated for the purpose of controlling the drive of the film web (13) and/or of the material strip (18).

20. (withdrawn) Apparatus according to Claim 7, characterized in that conveying elements for the material strip (18) and/or the film web (13) provided with material strip (18) and/or tear-open strip (12) can be controlled by the sensors - printed-mark readers (26, 30) - in respect of changing the drive speed of the film web (13) and/or material strip (18).

21. (currently amended) A process for producing cigarette packs (10) of the hinge-lid type with an outer wrapper made of film, comprising the steps of:

- a) providing a material strip (18) with precisely positioned printing or markings (24) ~~and for producing tear-open strips (12) with the precisely positioned printing or markings (24) thereon;~~
- b) attaching the tear-open strips (12) ~~with having~~ the precisely positioned printing or markings (24) thereon to a continuous film web (13) ~~from which individual blanks (11) for the outer wrapper comprising the tear-open strips (12) are produced;~~
- c) sensing the printing or markings (24) of the tear-open strips (12) with a print printed-mark reader (26);
- d) controlling the positioning of a severing cut for severing the individual blanks (11) comprising the tear-open strips (12) from the continuous film web (13) in accordance with the sensing of the printing or markings (24) of the tear-open strips (12); and then
- e) severing the individual blanks (11) for the use as an outer wrapper from the continuous film web (13) based on the sensing of the printing or markings (24) of the tear-open strips (12), wherein the blanks (11) comprise a portion of the continuous film web (13) and the tear-open strip (12) and whereby the printing or markings (24) of the tear-open strips (12) are positioned in a precise position relative to the blank (11).

22. (currently amended) An apparatus for producing cigarette packs (10) of the hinge-lid type with an outer wrapper made of film, comprising:
- a) means for providing a material strip (18) with precisely positioned printing or markings (24) and thereon for producing tear-open strips (12) ~~with the precisely positioned printing or markings (24) thereon~~;
 - b) means for attaching applying the tear-open strips (12) ~~with having~~ the precisely positioned printing or markings (24) thereon to a continuous film web (13) ~~from which individual blanks (11) for the outer wrapper comprising the tear-open strips (12) are produced~~;
 - c) a printed-mark reader (26), located proximal to a path of movement where the tear-open strips (12) are attached applied to the film web (13), for sensing the positions of the printing or markings (24) ~~ef on~~ the tear-open strips (12);
 - c) an evaluation unit, connected to the printed-mark reader (26), for evaluating the sensed positions of the printing or markings (24) on the tear-open strip (12); and
 - d) drive elements, which are controlled by the printed-mark reader (26) via the evaluation unit, for driving the continuous film web (13) so as to allow the severing of the individual blanks (11) for the outer wrapper from the continuous film web (13) at a position based on the sensing of the printing or markings (24) ~~ef on~~ the tear-open strips (12) whereby the printing or markings (24) of the tear-open strips (12) are positioned in a precise position relative to the blank (11).